

# Work Order ID 65424

Monday, January 17, 2011 1:21:18 PM



Page 1

Item ID: D4027-041

Accept



Setup Start



Revision ID:

Item Name: Hose Clamp Assembly

Stop



Start Date: 1/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-01-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4027

A

100

0.00



Small Fab

Memo

0.00

Small Fab

Drill hole and assemble as per dwg notes

*mf 11/01/11*



110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sublock*



120

Identify as per dwg & Stock Location: *451*

0.00



Packaging

Memo

0.00

Packaging

*11/1/2011*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65424**

Monday, January 17, 2011 1:21:18 PM

Page 2

Item ID: D4027-041

Accept

Revision ID:

Item Name: Hose Clamp Assembly

Start Date: 1/17/2011 Start Qty: 1.00

Required Date: 1/24/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/20 [Signature]

6601-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, January 17, 2011 1:21:14 PM

Page 1

Work Order ID: 65424

Parent Item: D4027-041

Parent Item Name: Hose Clamp Assembly





Start Date: 1/17/2011

Required Date: 1/24/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM IPP Rev:B  
10.05.17 as per ECN10-562 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4027-1  Hose Clamp		Manufactured	No			100	Each	8.0000	1	1			
<div> <div>Location</div> <div>ENG</div> <div>55195 ✓</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4027-87  Rubber Cushion		Manufactured	No			100	Each	2.0000	1	1			
<div> <div>Location</div> <div>ENG</div> <div>55880 ✓</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN743-13  BRACKET		Purchased	No			100	Each	16.0000	1	1			
<div> <div>Location</div> <div>ST329</div> <div>113706 ✓</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS24693-S28  Screw		Purchased	No			100	Each	170.0000	1	1			
<div> <div>Location</div> <div>ST288</div> <div>11334 ✓</div> </div> <div> <div>Loc Qty</div> <div>170</div> <div>100</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
<div> <div>Location</div> <div></div> <div>4824 ✓</div> </div> <div> <div>Loc Qty</div> <div></div> <div>21</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
<div> <div>Location</div> <div></div> <div>8170</div> </div> <div> <div>Loc Qty</div> <div></div> <div>49</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

m-d 11/01/18

1X

m-d 11/01/19 X

1X

m-d 11/01/19

1X

m-d 11/01/19

1X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Monday, January 17, 2011 1:21:14 PM

Work Order ID: 65424

Parent Item: D4027-041

Parent Item Name: Hose Clamp Assembly

Start Date: 1/17/2011

Required Date: 1/24/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN632J

AN960506

Purchased

No

100

Each

12.0000

1

1



Washer



m-h 11/01/19 \*

Location

M104537

Loc Qty

Loc Code

ST297

12

112794

12

No

100

Each

0.0000

1

1

MS21042L06

TRPO  
11.01.19  
051042

Purchased

M116082



Nut



m-h 11/01/19 \*

Monday, January 17, 2011 1:21:14 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

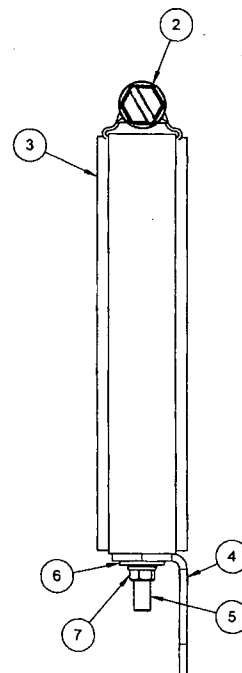
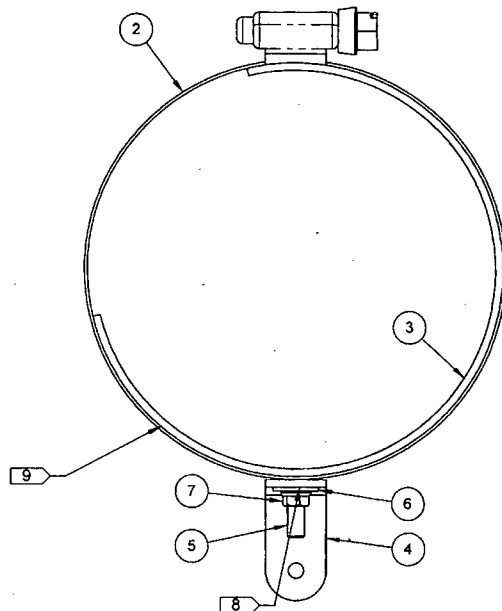
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L06	NUT	

11.01.19  
05/04/2



#65424

RELEASED  
2010-05-05

**D4027-041 VENT CLAMP ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

A	NEW ISSUE		10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4027** REV. A  
SHEET 1 OF 7

TITLE **CLAMP** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

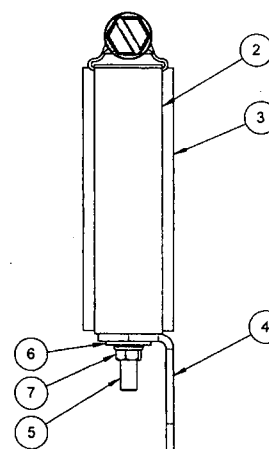
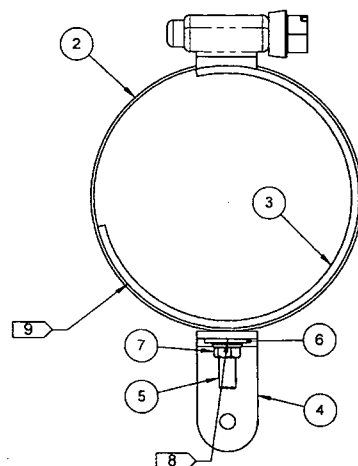
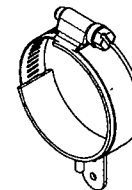
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-7	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



#65424

# D4027-043 VENT CLAMP ASSEMBLY

RELEASED  
2010-05-05  
NW

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4027	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

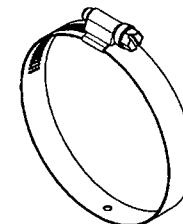
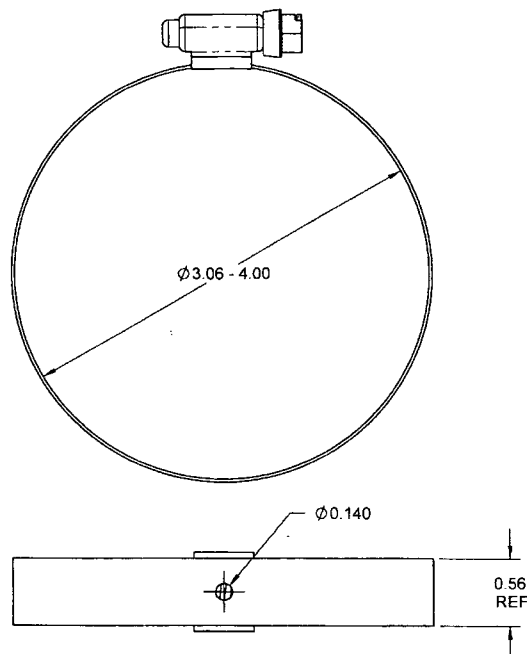
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20



**D4027-1 HOSE CLAMP**

#65424

RELEASED  
2010-05-15

**NOTES:**

- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4027</b> REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE <b>CLAMP</b> SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	10.04.16	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

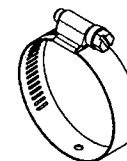
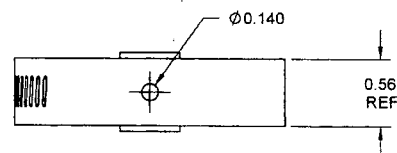
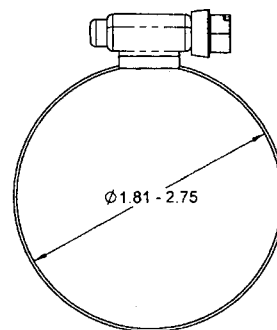
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-3	REF JCA-M47-2-35



#65424

**D4027-3 HOSE CLAMP**

**RELEASED**  
2010-05-15  
MB

**NOTES:**

- 1) MATERIAL: MADE FROM QS200M36S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4027</b>	REV. A
MFG. APPR.			SHEET 4 OF 7
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DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

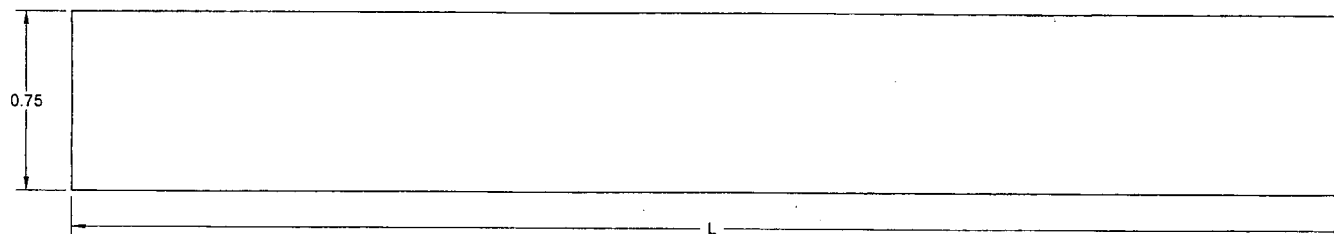
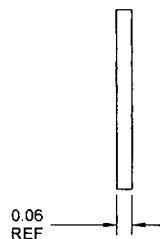
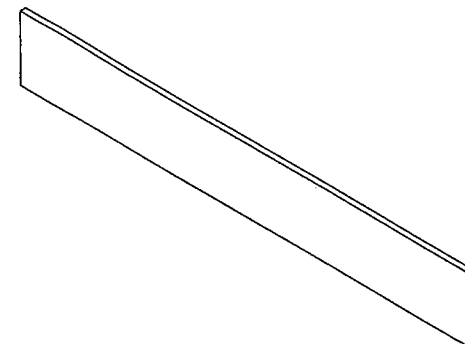
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35



DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

**D4027-X RUBBER CUSHION**

#65424

**RELEASED**  
R 2010-05-05  
MO

**NOTES:**

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK  
REF DART SPEC M-NEO-60-S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4027</b>	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		<b>CLAMP</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

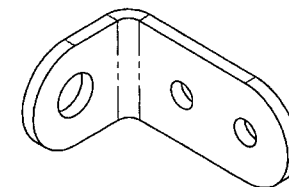
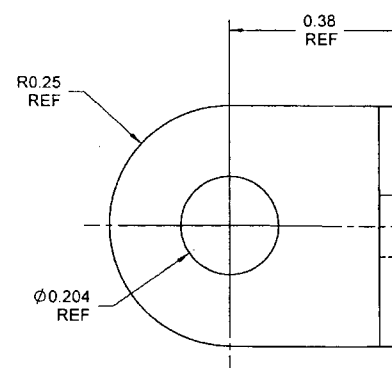
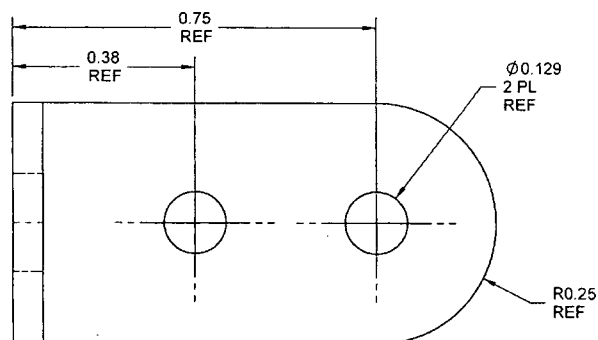
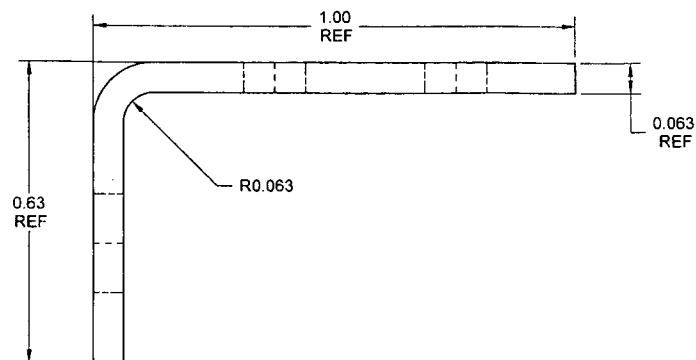
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-9	REF JCA-M47-2-20/-35



#65424.

RELEASED  
2010-05-05  
MP

**D4027-9 BRACKET, SUPPORT ANGLE**

- NOTES:
- 1) MATERIAL: MADE FROM D4027-9F OR EQUIVALENT TO AN743-C13
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.00 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4027</b>	REV. A
MFG. APPR.			SHEET 6 OF 7
APPROVED		TITLE <b>CLAMP</b>	SCALE
DE APPR.			NTS
DATE	10.04.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

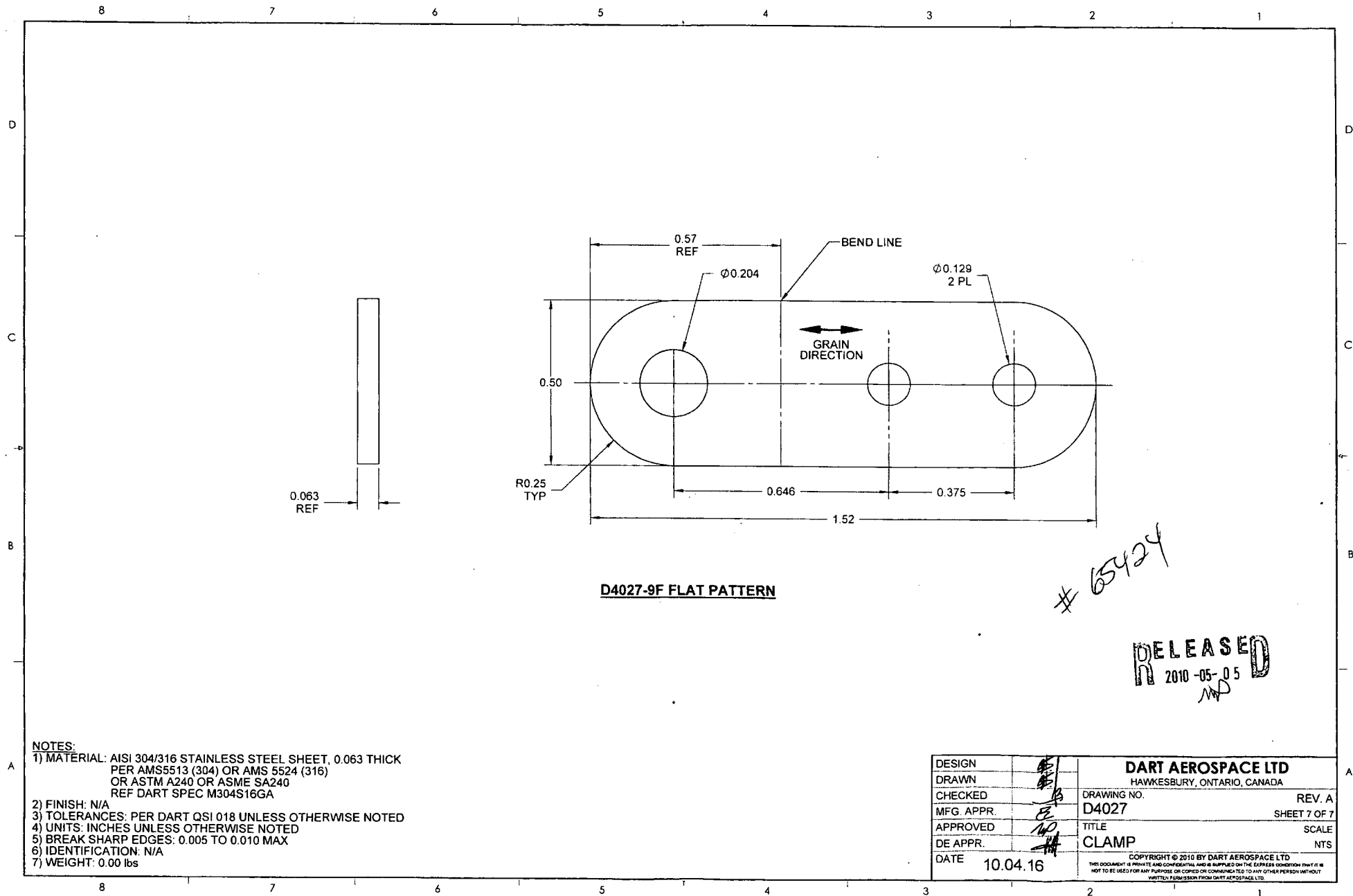
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**L Lacelle**

**From:** Marc Bellavance [mbellavance@dartaero.com]  
**Sent:** January 18, 2011 4:12 PM  
**To:** 'L Lacelle'  
**Subject:** RE: D4027

Yes, you are right. Longer in larger diameter, shorter in smaller diameter...

**Marc Bellavance**  
**Technical/Shop Support**

***DART aerospace Ltd.***

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Fax: 613-632-9311

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Web: [www.dartaero.com](http://www.dartaero.com)

**Product Documentation: Verify Revision Status/Download [HERE!](#)**



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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** January 18, 2011 1:41 PM  
**To:** 'Marc Bellavance'  
**Subject:** D4027  
**Importance:** High

Marc,  
Please take a look at this drwg, shouldn't the D4027-1 go with D4027-7 rubber (not -5 rubber) and vise-versa

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

1/19/11